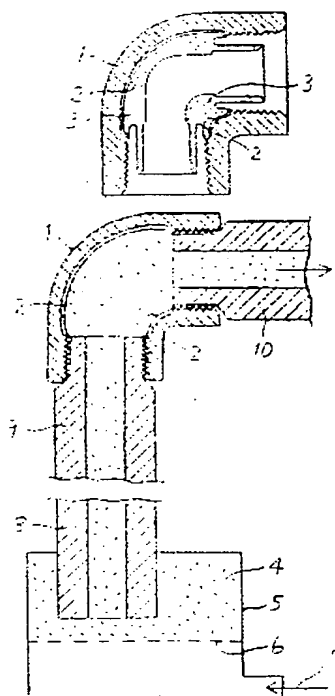


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 APPLICANT : HITACHI METALS LTD;
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 TUBE JOINT AND MANUFACTURE
 THEREOF



ABSTRACT : PURPOSE: To prevent a resin coating layer adhering to the inner face of a tube joint from separating by forming an adhering layer by coating it with powdery resin having adhesiveness with metal by a powder coating method.

CONSTITUTION: Hot melt powder resin 4 is guided to one opening end of a tube joint 1 heated to 140 - 150°C through a conduit 8 and a masking jig 9, a suction source is attached to the other end of another masking jig 10 attached to the other opening end of the joint 1, the inner faces of the joint 1 is coated with the resin 4 except a threaded part masked by the jigs 9, 10 to form an adhesive layer 2. Thereafter, thermoplastic resin is injection molded to the inner face of the layer 2 to form a resin coating layer 3. When the temperature of the resin to be fed to the mold is set to a temperature higher by 70 - 100°C than the melting point of the powder resin and injection molded, the hot melt resin is melted by the temperature of the resin to adhere integrally to the molding resin, and the layer 3 adheres to the inner face of the joint 1 through the layer 2.

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